

Work Order ID 57767

April 14, 2010 11:47:25 AM



Page 1

Item ID: D6201

Accept



Setup Start



Revision ID:

Stop



Item Name: "T" Extrusion

Start Date: 4/14/10 Start Qty: 12.00



Cust Item ID:

Required Date: 4/21/10 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: CZ

Date: 10/4/14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw/Nbr Revision Nbr

D6201 Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 11708 ☐ a) Description: T-beam extrusion ☐ b) 4.00" x 4.00" x 0.375" ☐ c) Minimum Ultimate Tensile Strength = 38ksi ☐ d) Minimum Yield Tensile strength = 35ksi ☐ e) Material: 6061-T6/T6511 (QQ-A-200/8) ☐ f) Material certification required

CZ 10/4/20 (20)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

P 10/4/23 (20)

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Item ID: D6201

Accept



Setup Start



Revision ID:

Stop



Item Name: "T" Extrusion

Start Date: 4/14/10

Start Qty: 12.00



Cust Item ID:

Required Date: 4/21/10

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6104

81004123

at length @ 20 feet.

130

Identify as per dwg & Stock Location: MAT

0.00

Packaging

Memo

0.00

Packaging

MF 10/04/26

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10604127
MF 10-4-26

Picklist Print

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Work Order ID: 57767



Parent Item: D6201



Parent Item Name: "T" Extrusion



Start Date: 4/14/10

Required Date: 4/21/10

Comments: IPP A: ☐01.05.15 ☐New Issue EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6201P  T Extrusion 4X4X3/8		Purchased	No			110	f	0.0000	12.0000 			

Pickup 23 (29)

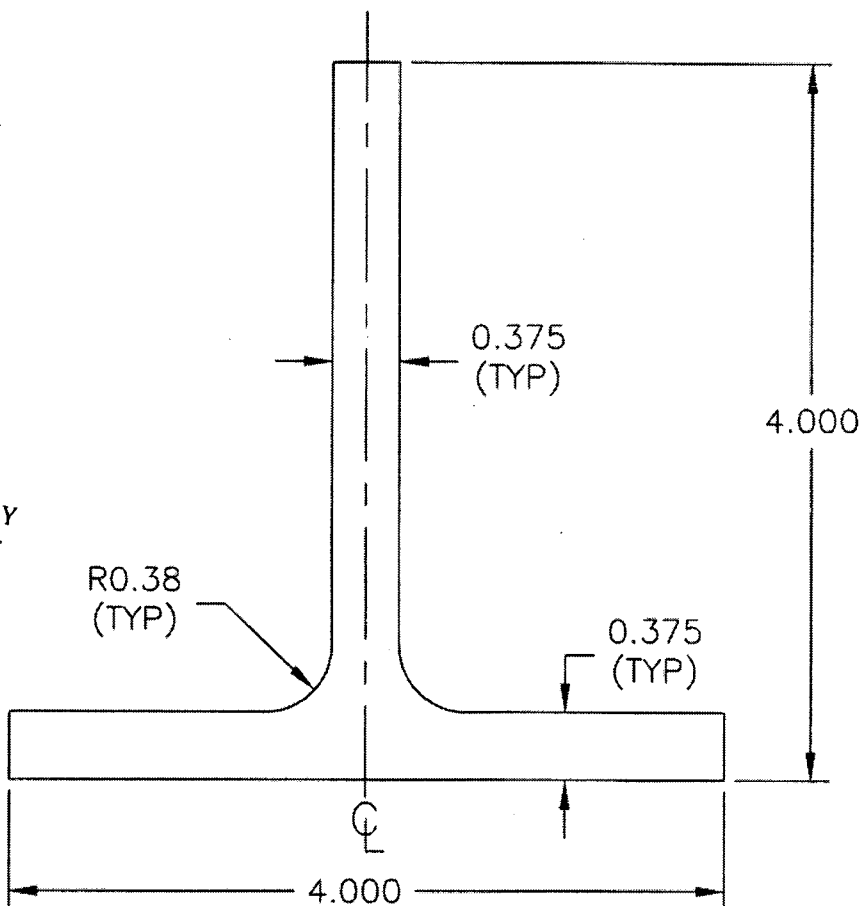


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>CP</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *#*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57267
C&D 4/14



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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PANASIA ALUMINIUM (CHINA) LIMITED

Aluminium Mill Certificate

Cert. No.: PAAV-MC0703036

CUSTOMER: Magna Stainless Inc

PO No.: 205404-JC

Contract No.: NIL

Alloy & Temper: 6061-T6511

Standards: ASTM-B308

Container No.: ZCSU8010606

Date of shipment: 2007.03.12

QQA-200/16

Chemical Composition (%)

Heat No.	Si	Mg	Fe	Cu	Mn	Zn	Cr	Ti	Al
Standard	0.40-0.80	0.80-1.20	0.7max	0.15-0.40	0.15max	0.25max	0.04-0.35	0.15max	Rem.
20070306401	0.489	0.880	0.242	0.194	0.026	0.038	0.047	0.018	Rem.

Tensile Test Result

Heat No.	Die No.	Customer part No.	Description	Tensile Strength		Yield Strength		Elongation
				N/mm ²	Ksi	N/mm ²	Ksi	%
20070306401	C10000071		Channel 6x2.5x0.25	280	41	255	37	11.0
20070306401	E10000004		Tee 4x4x0.375	285	42	255	37	10.8
20070306401	C10051		Channel 4x2x0.187	290	42	265	39	10.9

Hardness Test Result

Section No.	HRE	Webster	Other Remarks
C10000071	91	15.6	
E10000004	94	16.2	
C10051	92	15.9	

The above result was done on testing samples and the mill shall guarantee the same quality for the same batch of products. It is certified that this material conforms in all respects to the requirements of the above standards latest revision.

QC: Chenghao Zhong

Checked by: Junxian Luo



OK
10.04.22

BW-550
10/4/23



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11708

Purchase Order Date 4/20/10

PO Print Date 4/20/10

Page Number 1 of 2

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

FAXED
613 632 1053

Contact Name
Vendor Phone 800 363 6646
Vendor Fax 514 339 1105
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD

FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6201P	T Extrusion 4X4X3/8	4/26/10 Yes	20.00 f	Yours ppd	\$9.7500	\$195.0
		<div><div><p>ASTM B305 OK QP 10-4-12</p></div><div>Special Inst:</div></div>					
		T-BEAM EXTRUSION SIZE: 4.00" X 4.00" X 0.375" MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI MINIMUM YIELD TENSILE STRENGTH = 35 KSI MATERIAL: 6061-T6/T6511 AS PER QQ- A-200/8					
2	M6061T6B30000X01.500	6061-T6 Bar 3.00 x 1.50	4/26/10 Yes	20.00 f	Yours ppd	\$12.0000	\$240.0

Special Inst: MATERIAL: 6061-
T6/T651/T6510/T6511/T62
ALUMINUM BAR AS PER QQ-A-225/8
OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116 OR QQ-A-
200/8 OR AMS-QQ-A-200/8
OR AMS 4160 OR ASTM B221 OR ASTM
B221

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 4/20/10



SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY , ON
K6A 1K7
Ship Terms: PREPAID



SPECIAL INSTRUCTIONS

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO		
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	P0011708		
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W028675	NET 30 DAYS		NIR:R-557065-1		04/22/10	04/23/10	04/23/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM FLATS AFL 6061 T6 1-1/2" x 3" x R/L 20' 108 LB / 1 PC	L031416	7787	1 1
1		PC	ALUMINIUM TEE ATE 6061 T6 3/8" x 4" x 4" x R/L 20' 69 LB / 1 PC	L007892	0070306401	1 1
Bundles: 1				Approx	Weight:	177 LB

Received by: _____ Date: _____ Signature: _____